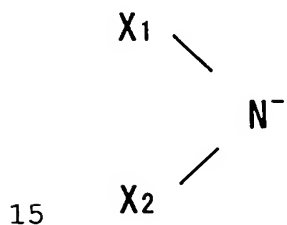


WHAT IS CLAIMED IS:

1. A flame-retardant seamless belt composed of a thermoplastic composition containing a polyester thermoplastic elastomer as a main component thereof; at not less than 15 wt%  
5 nor more than 40 wt% of melamine cyanurate, serving as a flame-retardant additive, for a whole weight of said thermoplastic composition; and not less than 0.01 parts by weight nor more than three parts by weight of an anion-containing salt, shown by a chemical formula 1 shown below,  
10 for 100 parts by weight of an entire polymer component,

wherein said thermoplastic composition has a volume resistivity of not less than  $1.0 \times 10^6 \Omega \cdot \text{cm}$  nor more than  $1.0 \times 10^{12} \Omega \cdot \text{cm}$ .

Chemical Formula 1



where  $X_1$  and  $X_2$  denote functional group, containing C, -F, and -SO<sub>2</sub>-, whose number of carbon atoms is one to eight.

2. The flame-retardant seamless belt according to claim 1, wherein said  $X_1$ - of said chemical formula 1 is  
20  $C_{n1}H_{m1}F_{(2n1-m1+1)}-SO_2-$ , and said  $X_2$ - of said chemical formula 1 is  $C_{n2}H_{m2}F_{(2n2-m2+1)}-SO_2-$  ( $n_1$  and  $n_2$  are integers not less than 1, and  $m_1$  and  $m_2$  are integers not less than 0).

3. The flame-retardant seamless belt according to claim 1, wherein a cation making a pair with said anion, shown by said chemical formula 1, which constitutes said salt is a cation of any one of alkali metals, group 2A metals, transition metals, and amphoteric metals.

4. The flame-retardant seamless belt according to claim 3, wherein a metal constituting said cation is lithium.

5. The flame-retardant seamless belt according to claim 1, wherein said anion-containing salt is lithium-bis (trifluoromethanesulfonyl) imide.

6. The flame-retardant seamless belt according to claim 1, wherein said anion-containing salt shown by said chemical formula 1 is added to said entire polymer component without intermediary of a medium consisting of a low-molecular-weight polyether-containing compound or a low-molecular-weight polar compound whose molecular weight is not more than 10000.

7. The flame-retardant seamless belt according to claim 1, wherein supposing that a volume resistivity of said flame-retardant seamless belt measured at a low temperature of 10°C and a low humidity of 15% is  $R_{LL}$  and that a volume resistivity thereof measured at a high temperature of 32.5°C and a high humidity of 90% is  $R_{HH}$ , the volume resistivity  $R_{LL}$  and the volume resistivity  $R_{HH}$  satisfy an equation of  $\log_{10}R_{LL} - \log_{10}R_{HH} \leq 2.5$ .

8. The flame-retardant seamless belt according to claim

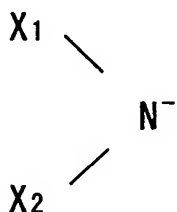
1, having at least one coating layer on a peripheral surface thereof.

9. A method of manufacturing a flame-retardant seamless belt comprising the steps of:

5 fusing and kneading, by an extruder, a conductive master batch containing a polyester thermoplastic elastomer and not less than one wt% nor more than 20 wt% of an anion-containing salt, shown below by a chemical formula 1, added to said polyester thermoplastic elastomer; a flame-retardant additive;  
10 and a thermoplastic composition containing said polyester thermoplastic elastomer as a main component thereof to form a material for said flame-retardant seamless belt; and

extruding said material from an annular die and molding said material into a shape of a belt by using a sizing die.

15 Chemical Formula 1



Where  $X_1$  and  $X_2$  denote functional group which contains C, -F, and -SO<sub>2</sub>- and in which the number of carbon atoms is one to eight.

20 10. The method according to claim 9, wherein said flame-retardant additive and said thermoplastic composition containing said polyester thermoplastic elastomer as said main

component thereof are kneaded and supplied to said extruder as a flame-retardant master batch; and said mixture of said conductive master batch and said flame-retardant master batch are extruded vertically from said annular die.

- 5            11. An image-forming apparatus having said flame-retardant seamless belt according to claim 1.